

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023288**Date Inspected:** 27-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Suspender Bracket / Outside Blast Shop 2

This QA inspector performed Magnetic Particle Testing (MT) on Suspender Bracket SB-108-East after HSR & overlaying that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

Suspender Bracket / Outside Blast Shop 2

This QA inspector performed Ultrasonic Testing (UT) on Suspender Bracket SB-108-East after HSR & overlaying that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

Bay 19 / Cable Bracket

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of Cable Bracket SA6531 weld # SA6531-001-001. The welder is identified as 062808. Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

Bay 19 / Cable Bracket

WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of Cable Bracket SA6529 weld # SA6529-001-007. The welder is identified as 062807. Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

Bay 19 / Cable Bracket

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of Cable Bracket SA6529 weld # SA6529-001-088. The welder is identified as 062757. Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB. See attached photograph Pic_001.

Bay 19 / Cable Bracket

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of Cable Bracket SA6531 weld # SA6531-001-005. The welder is identified as 062739. Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

Bay 19 / Cable Bracket

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of Cable Bracket SA6530 weld # SA6530-001-004. The welder is identified as 062749. Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

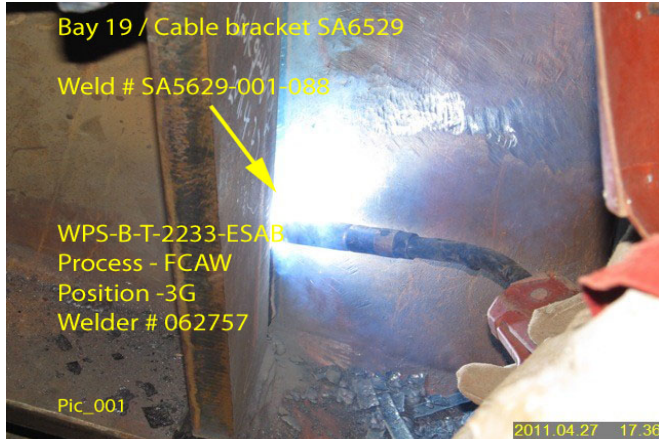
Bay 14 / U Rib Splice Plate

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of U Rib Splice Plate weld # x3305K-048-001. The welder is identified as 052830. Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

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Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey (+86) 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
